

Date: Tuesday, 12/20/2005 2:50:19 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: LITTER DECKPLATE 350
Job Number	: 25294		
Estimate Number	: 10357		
P.O. Number	: N/A	Part Number	: D2344
This Issue	: 12/20/2005 S.O. No. : N/A	Drawing Number	: D2344 REV.E
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : MACHINED PARTS	Drawing Revision	: E
Previous Run	: N/A	Material	: N/A
Written By	: SEE COMMENT BELOW	Due Date	: 1/15/2006
Checked & Approved By	: SEE ABOVE USER	Qty:	10 Um: Each
Comment	: Est Rev:D 00.06.26 Removed P/O for powder coat EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M2024T3S063	2024-T3 .063 sheet
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Comment: Qty.: 0.7823 sf(s)/Unit Total: 7.8225 sf(s)
 Material: 2024-T3 QQ-A-250/5) .063
 Batch *M19059*

En 06/02/06

2.0	SHEAR	SHEAR
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Comment: Shear blanks: 17.100" X 6.380" +0.015/-0.000

En 06/02/06 x10

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: Haas #1
 Machine per folio D2344 & dwg D2344

J.L 06.02.06 10

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.L 06.02.06 10

5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

BT 06.02.06 10

6.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE-1
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Comment: SMALL/MED FAB

1-Deburr sharp edges *SAD 06302215 -10*

2-Countersink holes per Dwg D2344

SB 06/02/06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: DD Date: 06/02/23

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

QC5

INSPECT WORK TO CURRENT STEP



Job 06-02-21

Comment: INSPECT WORK TO CURRENT STEP

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

FC 06 02 21

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

m 06 02 22 10

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: Identify and Stock

Location: *51 171*

06/2/22 10

11.0

DC

DOCUMENT CONTROL



Comment: Inspection Level 21

19 06 02 23

Job Completion



u 06-02-23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	25294
Description: Litter Deck Plate Kit (350)		Part Number:	D2344
Inspection Dwg: D2344 Rev: E		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.991	+/-0.005	.991	✓			
6.223	+/-0.010	6.222	✓			
5.598	+/-0.010	5.597	✓			
4.869	+/-0.010	4.869	✓			
3.889	+/-0.010	3.889	✓			
3.096	+/-0.010	3.096	✓			
2.891	+/-0.010	2.891	✓			
16.973	+/-0.010					can't measure
0.966	+/-0.005					
0.450	+/-0.010	.450	✓			
4.423	+/-0.010	4.423	✓			
4.723	+/-0.010	4.723	✓			
1.202	+/-0.010	1.202	✓			
5.869	+/-0.010	5.868	✓			
4.654	+/-0.010	4.654	✓			
Ø0.656	+0.005/-0.000	.655	✓			
1.888	+/-0.010	1.888	✓			
2.285	+/-0.010	2.285	✓			
2.683	+/-0.010	2.682	✓			
Ø0.171	+0.005/-0.000	.174	✓			
0.750	+/-0.005	.750	✓			
3.491	+/-0.010	3.491	✓			
Ø0.191	+0.005/-0.000	.192	✓			
0.796	+/-0.005	.796	✓			
3.123	+/-0.010	3.123	✓			
1.527	+/-0.010					can't find
1.975	+/-0.010	1.975	✓			

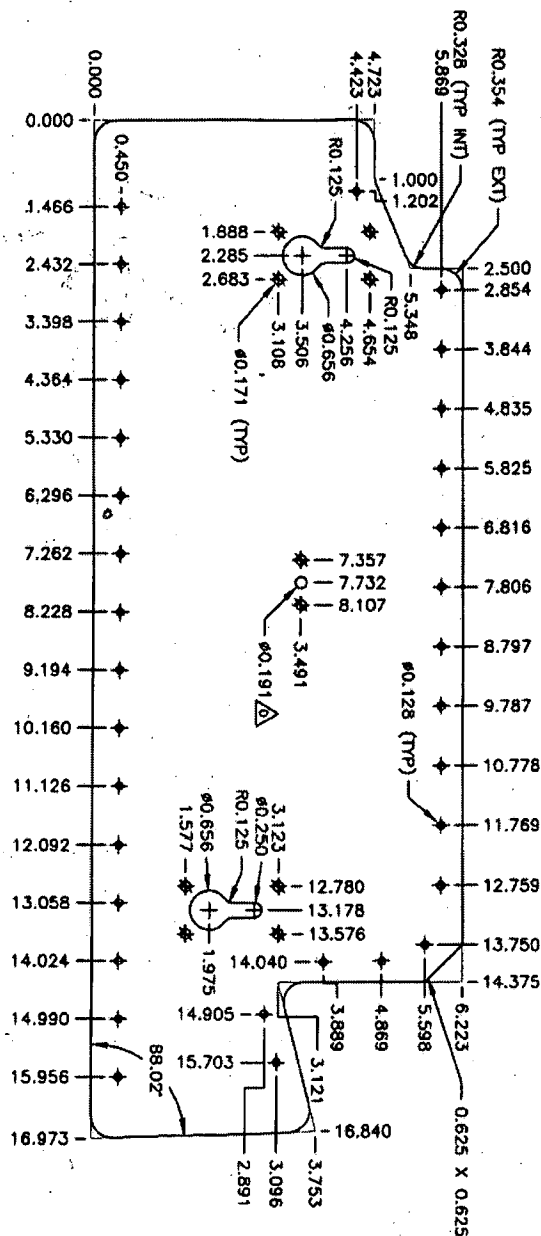
Measured by:	JL
Date:	06-02-06

Audited by:	En
Date:	06/02/06

Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.06.25	New Issue	P/O D350-616-015	KJ/JLM

COUNTER SINK HOLES:
 ◆ C'SINK Ø0.225 x 100°
 ◆ C'SINK Ø0.308 x 100°



MATERIAL: 2024-T3 (QQ-A-250/5) 0.063-0.071 THICK
FINISH: POWDER COAT BLACK CRINKLE (4.3.5.3) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	DRAWING NO. D2344	CHECKED <i>[Signature]</i>	DATE 98.06.19
REV. E SHEET 1 OF 1	TITLE LITTER DECK PLATE, 350	APPROVED <i>[Signature]</i>	
A	NEW ISSUE	B	Moved KEY HOLES
D	0.191 WAS 0.197	E	0.063-0.071 THICK WAS 0.071 (TSR A371)

RELEASED 10/18/22



